

Work Order ID 100091

Thursday, April 18, 2013 8:24:22 AM

100091

Skip Friday/Monday

Item ID: DSI 9638-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop ***NS2***

Item Name: Engine Mount Upgrade

Start Date: 4/18/2013 Start Qty: 5.00

5

Cust Item ID:

Required Date: 4/19/2013 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan: *MUF*

Date: 13-4-17 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

DSI 9638

B

u SP

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP DSI9638-011 CHG001

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

Work Order ID 100091

100091

Page 2

Thursday, April 18, 2013 8:24:22 AM

Item ID: DSI 9638-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Engine Mount Upgrade

Stop *NS2*

Start Date: 4/18/2013 Start Qty: 5.00

5

Cust Item ID:

Required Date: 4/19/2013 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP DSI9638-011								
	Location: 032								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

Raw A

AS 008

13-4-23

MCJ

13-04-23

MF 13-4-23

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

Thursday, April 18, 2013 8:24:21 AM

Page 1

Work Order ID: 100091
Parent Item: DSI 9638-011
Parent Item Name: Engine Mount Upgrade

Start Date: 4/18/2013

Required Date: 4/19/2013

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 12.12.03 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
HL32PB8-11 Pin		Purchased	No				Each	14.0000	2	10			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST284		14							
				123916		14							
HL32PB8-14 Pin		Purchased	No				Each	157.0000	220	110			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST284		157							
				123916		157							
HL86-8 Collar		Purchased	No				Each	272.0000	120				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST284		272							
				124724		272							
08-550 Drill Bit		Purchased	No				Each	0.0000	120				
13-420 Piloted Drill		Purchased	No				Each	44.0000	5				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST284		44							
				124728		44							
44-300 Step Reamer		Purchased	No				Each	36.0000	5				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST284		36							
				124728		36							

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
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FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
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		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

Shp B423

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D205-770 REV. C
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-770 REV. 2

REF. TCCA STC: SH08-8

REF. FAA STC: SR02690NY / SR02070SE

REF. EASA STC: EASA.IM.R.S.01528

1.0 PURPOSE

On D205-770-011 Replacement Engine Mount Kits at CHG 006 or later, the AN3C12A Bolts, D3692-1 Spacers, and MS21043-3 Nuts on the upper and lower ends of each leg are replaced with HL32PB8-11/-14 Hi-Lok Pins and HL86-8 Hi-Lok Collars to prevent premature loosening and/or bolt failure in service. The adhesive used to assemble the rod end bearings has also been changed from Sikaflex-291/Proseal 890 to Hysol 934NA or Magnabond 6398. Customers with D205-770-011 Replacement Engine Mount Kits at CHG 005 or earlier are encouraged to procure the DSI 9638-011 Kit from Dart to upgrade their existing kits. Note: this service instruction supersedes DSI 9571.

2.0 INSTALLATION

- 2.1 Remove the engine mounts from the aircraft per ICA-D205-770. Inspect D3693-1 Rod End Bearings for play and for suitability for continued service. Replace if required.
- 2.2 Remove qty(1) AN3C12A Bolt from each end of each engine mount leg. Ensure holes are not elongated more than 0.030". If holes are elongated by more than 0.030", then parts will need to be replaced.
- 2.3 Clean each hole using drill bit P/N 08-550.
- 2.4 Enlarge each hole using Piloted Drill P/N 13-420.
- 2.5 Ream each hole to Ø0.248 using Step Reamer P/N 44-300.
- 2.6 Install an AN4-12A Bolt and MS21042-4 Nut in each reamed hole and tighten.
- 2.7 Remove remaining AN3C12A Bolts and repeat steps 2.2 through 2.4.
- 2.8 Mark each end of the legs to ensure all parts will be re-assembled in original location and orientation.
- 2.9 Disassemble engine mounts, de-burr, and clean all parts making sure to remove all traces of existing sealant while keeping intact the markings performed at Step 2.8.
- 2.10 Re-assemble engine mounts using Hysol 934NA or Magnabond 6398 adhesive and P/N HL32PB8-11/-14 and HL86-8 Hi-Lok fasteners.
Note: Before permanent installation of hi-loks on the D3684-041 Tripod Assembly, confirm clearance of engine throttle linkage and position hi-lok collars to maximize clearance.
- 2.11 Make an entry in the log book that the replacement engine mount kit has been reworked to DSI 9638 Rev. B, and re-install the engine mounts in the aircraft per ICA-D205-770.

3.0 PARTS LIST

Qty	Part Number	Description
011	DSI 9638-011	UPGRADE KIT
X		
2	HL32PB8-11	HI-LOK PIN
22	HL32PB8-14	HI-LOK PIN
24	HL86-8	HI-LOK COLLAR
1	08-550	DRILL BIT
1	13-420	PILOTED DRILL
1	44-300	STEP REAMER






4.0 WEIGHT & BALANCE

This change has negligible effect on weight and balance

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 12.12.21
CERT. NO.: SH08-8
ISSUE NO.: 1

B	ADDED WARNING ABOUT ORIENTATION OF HY-LOKS	MB	12.12.20
A	NEW ISSUE	MB	12.11.26
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9638	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ENGINE MOUNT UPGRADE KIT	NTS
DATE	12.12.20	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Work Order ID 100091***100091***

Thursday, April 18, 2013 8:24:22 AM

Ship Friday/monday Page 1

Item ID: DSI 9638-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Engine Mount Upgrade

Stop ***NS2***

Start Date: 4/18/2013 Start Qty: 5.00

5

Cust Item ID:

Required Date: 4/19/2013 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan: *MF*

Date: 13-4-17 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

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Work Center IDOperation
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Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

DSI 9638

B

u Sp.

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP DSI9638-011 CHG001

*MLJ 13-04-19**5*

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

*5x**SP 13-4-18*

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control